

Work Order ID 118401

118401

Page 1

September-04-14 3:13:39 PM

Item ID: D119-646-211 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube with Run-On Landing Wearplates LH
 Start Date: 9/04/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/12/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference: REWORK RS1015

Approvals: Process Plan Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D119-646	B

100 Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile & type labels per PPP D119-646-211
CHG004

0.00

101

0.00

101

Skidtubes

Skidtubes

Memo

PULL FROM STK:
1 X D119-646-211 B121926 CHG004

FWD GHW HOLES DO NOT ALIGN
REWORK PER RS1015

KEEP ORIGINAL KIT AND PUT ASIDE TO BE REPACKAGED ONCE
TUBE IS REWORED

DART		170 ABERDEEN ST HAWKESBURY ON CANADA K6A 1K7 TEL: 613-632-5200 www.dartcorp.com	
PATENT	US #5735484 / CA #2222184 / EURO #0828655		
PIN	D119-646-211	CHG	CHG004
DESC	Skidtube STD, LH	STC	SR02024SE
LOT	B121926	STC	
MODEL	Agusta A119/AW119MKII	STC	
TO APPROVAL #09-89		MADE IN CANADA 02729-4	

B118401 LH

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
102		0.00							
102									
HandFinish	Memo	0.00							
Hand Finishing	REMOVE FWD AND AFT CAP -SET ASIDE TO RE-INSTALL CLEAN OFF SIKAFLEX								
103	QC5- Inspect part completeness to step on W/O	0.00							
103									
QC	Memo	0.00							
Quality Control									

 14-9-5

N/A

 14-9-5

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 Reference: REWORK RS1015

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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104

0.00

104

Skidtubes

Skidtubes

Memo

0.00

1-DRILL OUT AND REMOVE CROSS BOLT SPACERS D2579 IN
 DETAIL C ON DWG D3887

2-REPOSITION LOCATION OF HOLES AS PER DWG BUT USING
 +/-0.005" TOL AND PER SYMMETRICAL IN QSI018

3- TACK ONLY CROSS BOLT SPACERS D2579 B 113785 x2 BE 14-09-05

4-REAM HOLES TO MAX TOLERANCE AS PER QSI018

5-TEST FIT GRD HANDLING FIXTURE

105

QC5- Inspect part completeness to step on W/O

0.00

105

QC

Quality Control

Memo

0.00

LOCATION MUST BE VERIFIED BY QC
 RECORD DIMS:

105.1 Outsource- Send to JMI for print 5/14/09/22
 stripping PD 25865

105.2 Packaging - Receive & Inspect

105.3 QC - QC6 Serial 12

CY 14/09/22 ①

1X SP 14-10-14

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118401

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 Item Name: Skidtube with Run-On Landing Wearplates LH
 Start Date: 9/04/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/12/14 Req'd Qty: 1.00 *1* Customer:
 Reference: REWORK RS1015

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00	NOV 04 2014						
Quality Control									
130		0.00							
130									
Packaging	Memo	0.00	NOV 04 2014						
Packaging	REPACKAGE USING NEW B/N								
	Identify and pack for shipping as per PPP D119-646-211								
	Location: 089								
	PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14/11/14
 MF
 14-11-04

Picklist Print

September-04-14 3:13:39 PM

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Work Order ID: 118401

118401

Parent Item: D119-646-211

D119-646-211

Parent Item Name: Skidtube with Run-On Landing Wearplates LH

Start Date: 9/04/14

Required Date: 9/12/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP Rev:B

12.09.12 as per ECN12-644 DD verf:JLM

IPP REV:C 12.11.05

raise to chg003 (ECN 12-675) DD verf:JLM IPP REV:D 13.03.20 raise to

chg004 (ECN 13-534) DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D119-646-211

Manufactured

No

Each

2.0000

1

D119-646-211

Skidtube with Run-On Landing Wearplates LH

Location

Loc Qty

Loc Code

FG084

2

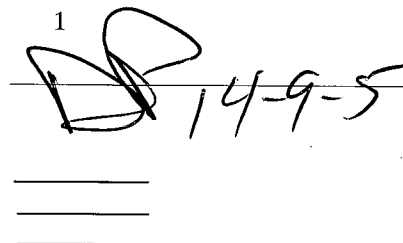
120985

1

122219

1

B121926



DART AEROSPACE LTD		Work Order:	11401
Description: Repair Scheme D119-646-241 Skid tubes FWD GHW holes do not align NCR 14-3771 For tubes in production and Returned tubes			
Drawing: D3887	Repair Scheme:	RS1015	
Part No: D119-646-241	Page:	1 of 1	
Batch No:	Qty:	1	

Step	Location	Procedure	By	Date	Qty
1	Finishing	Remove FWD & AFT caps D2855-3. Clean all sikaflex off cap & identify per each tube caps was removed (P/N & B#)	DP	14-9-5	1
2	Skidtube	Drill out & remove FWD Cross bolt spacers D2579 in Detail C on Dwg D3887	DP	14-9-5	1
3	Skidtube	Reposition location of holes as per Drawing but using <u>+/-0.005" tol</u> and per symmetrical in QSI 018	DP	14-9-5	1
4	Skidtube	TACK ONLY Cross bolt spacers D2579 B <u>113785</u> x2	BB	14-09-05	1
5	QC	Location MUST be verified by QC Record Dims HERE <i>P.H.D 3.7.</i>	S	14/09/08	1
6	Skidtube	Weld as per QSI 004 A/R <u>11129399</u> Back Drill Grind welds flush & deburr	BE	14-09-08	1
			DP	14-9-8	1
7	QC	QC 10 & 5 Inspection ***TEST FIT GHW WHEELS*** Pass <input type="checkbox"/> <i>P.H.D 3.7</i>	S	14/09/08	
8	Finishing	Touch up alodine as per QSI 005	M	14/10/20	x1
9	Finishing	Touch up Powder coat per QSI 005	34 DAS	14/10/18	1
10	Finishing	Re-assemble original caps back on tubes Sikaflex B <u>130225</u> exp <u>15/08</u>	DP	14/10/20	x1
11	QC	QC 3 inspect			
12	QC	QC 5 inspect			
13	QC	QC21			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.04.29	New Issue	ED		

U:\Admin\Forms\RepairschemblA.doc

Rev. A



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25865

Purchase Order Date 9/22/2014

PO Print Date 9/22/2014

Page Number 1 of 3

Order From :

VC-IMI001

IMI MANUFACTURING INC.
772 MAIN ST. E.P.O. BOX 3
HAWKESBURY, ON K6A 2R4
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID

Contact Name

Vendor Phone 613 675 1208 Ext.223

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	118400	D119-646-212 Skidtube	9/22/2014 Yes 9/26/2014		1.00 ✓	\$50.00	\$50.00
To cover the cost of pain stripping. Strip product supplied. B118400							

Line Total: \$50.00

2	118401	D119-646-211 Skidtube	9/22/2014 Yes 9/26/2014		1.00 ✓	\$50.00	\$50.00
To cover the cost of pain stripping. Strip product supplied. B118401							

Line Total: \$50.00

8814-10-14

Note:

9/22/2014



Manufacturing Inc.

2056 County Rd #4, L'Original, Ontario K0b 1K0

Phone 613-675-1208

Fax 613-675-1250

PACKING SLIP

TO : DART AEROSPACE
1270 Aberdeen Street
Hawkesbury ON
K6A 1K7

Date : October 14 2014

SALESPERSON:		JOB # 14-0464-22	PO NUMBER : 25865	
QTY ORDER	DESCRIPTION		QTY SHIP	LINE TOTAL
6	SKIDTUBE		6 ✓	1
2014-10-14				

Client: (PRINT NAME) _____ (SIGNATURE) _____

THANK YOU FOR YOUR BUSINESS!

New Parts

Part no:	BATCH no:	QTY:
D2855-3	B117601	(2x)
D3672-1	M113581	(2x)
D3904-1	M113662	(1x)
AN3C-5A	M130358	(2x)
AN3C-46A	M129043	(5x)
AN3C-46A	M128991	(3x)
M1521043-3	M130184	(8x)
M5246941-C52	M127059	(2x)

*All installed by JD 14/10/20 (1x)